

Work Order ID 147206

June 07, 2016 11:32:32 AM

647.3804

B 147206

147206

Page 1

Item ID: 647.3804

Revision ID:

Item Name: Lower Cutter Assy High

Start Date: 6/7/2016 Start Qty: 2.00

Required Date: 6/10/2016 Req'd Qty: 2.00

Reference:

REV. N/C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: SA

Date: 6/7/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.3800

n/c

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.13

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M135047
exp. date: 6/18DAS
30
9-89

AUG 24 2016

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

JAS
38
9-89

AUG 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

June 07, 2016 11:32:32 AM

Page 2

AUG 26 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
198 - 200				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Picklist Print

June 07, 2016 11:32:32 AM

Page 1

Work Order ID: 147206

147206

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assy High

Start Date: 6/7/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

646.9701

Manufactured

No

110

Each

5.0000

1

646.9701

Cutter Sub Assembly

**

24
XB145346 PC

Location

Loc Qty

Loc Code

cck012

5

142645

2

142646

3

NAS1149FN832P

Purchased

No

110

Each

1,989.000

6

NAS1149FN832P

Washer

**

12-18 PC

Location

Loc Qty

Loc Code

GA

457

M133316

16

M133769

441

ST260a

1200

M134257

1200

ST264

332

M133709

332

18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Picklist Print

June 07, 2016 11:32:32 AM

Page 2

Work Order ID: 147206

Parent Item: 647.3804

Parent Item Name: Lower Cutter Assy High

147206

647 3804

Start Date: 6/7/2016

Required Date: 6/10/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

110

Each

991.0000

3

MS21042I 08

Nut

**

9
X M 135 046 PC

Location

Loc Qty

Loc Code

GA

310

m133134

3

m134063

307

ST303

537

m133922

37

m134574

200

m134654

300

ST308

144

m134376

144

MS27039-08-19

Purchased

No

110

Each

517.0000

3

MS27039-08-19

Screw

**

292
X M 135 468 PC

Location

Loc Qty

Loc Code

GA

218

m132930

84

m133077

22

m134063

112

over006

100

m134294

100

ST277

199

m134142

199

647.3902

Manufactured

No

110

Each

0.0000

1

647 3902

Lower Deflector Assembly, High

**

23
X M 147 427 PC

ck074

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

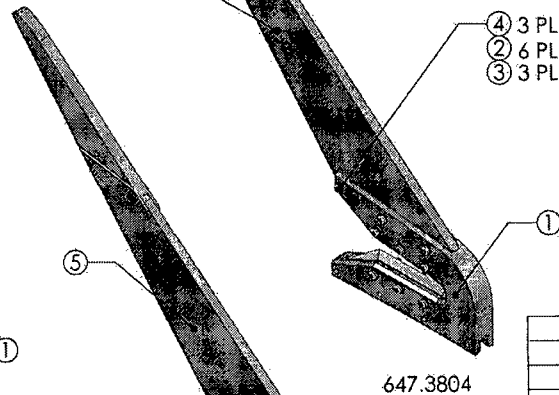
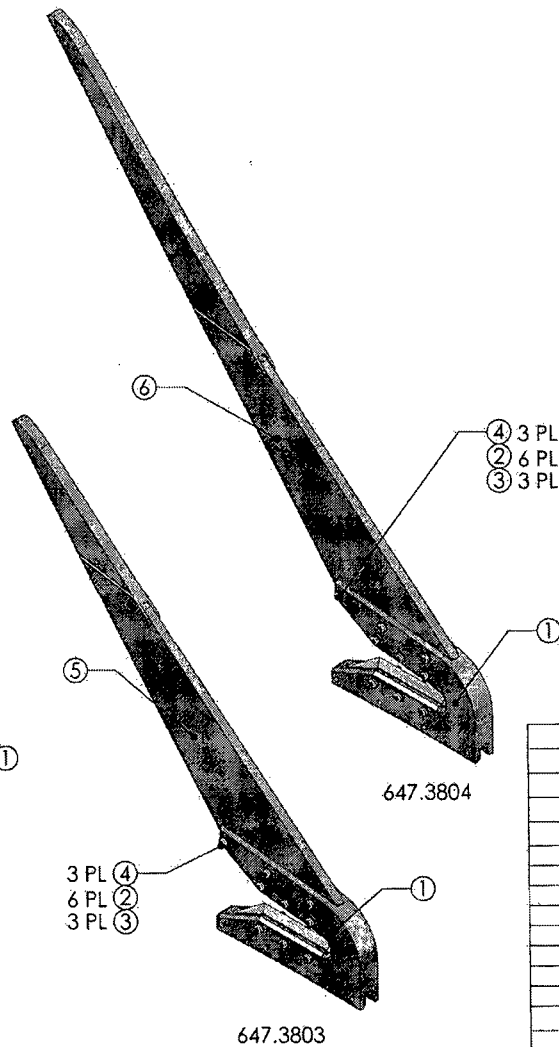
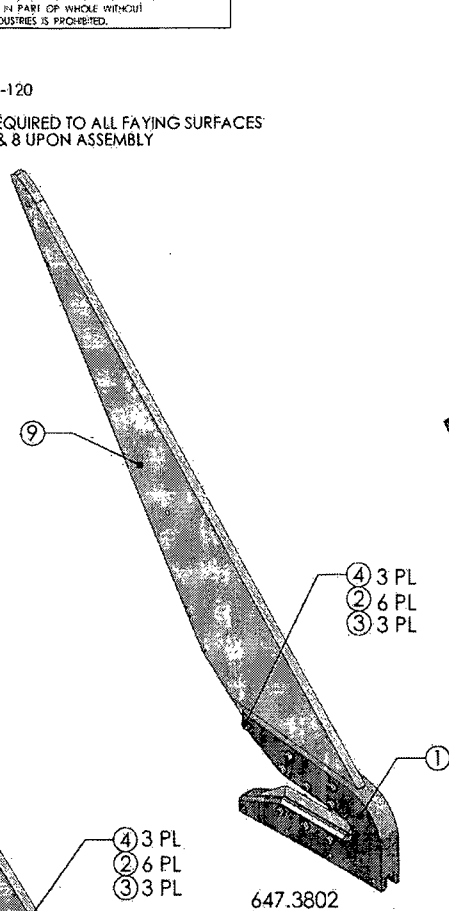
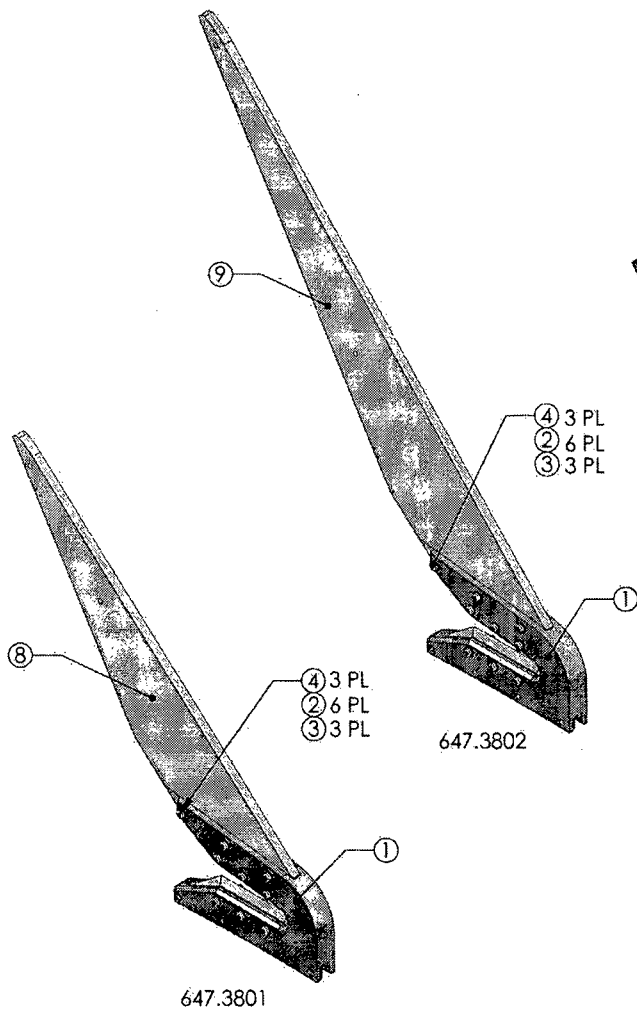
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OTHER : _____					

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NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE RELEASE		TMC
2	FINAL RELEASE	09/08/01	J. SPAYO



9	647.3911	212 UPPER DEFLECTOR		
8	647.3910	412 UPPER DEFLECTOR		
7	601.2045	RTV, LOCTITE 598		
6	647.3902	LOWER DEFLECTOR ASSY HIGH		
5	647.3901	LOWER DEFLECTOR ASSY LOW		
4	601.2765	SCREW	MS2700P0019	
3	601.1541	LOCKNUT	MS21042L08	
2	601.2764	WASHER	11451149H032P	
1	646.9701	CUTTER SUB ASSY		
	647.3804	LOWER CUTTER ASSY HIGH		
	647.3803	LOWER CUTTER ASSY LOW		
	647.3802	212 UPPER CUTTER ASSY		
	647.3801	412 UPPER CUTTER ASSY		
	3804, 3803, 3802, 3801	FIND #	PART #	DESCRIPTION
	QTY			MATL
	NEXT ASSY (\$)			SPEC.
	647.3700			
PARTS LIST				
ORIGINAL DATE: 09/08/01				
DRAWN BY: J. JACKSON				
CHECKED BY: D. BARNER				
DESIGNED BY: J. SPAYO				
APPROVED BY: J. SPAYO				
CONTRACT NO.				
THICKNESS DIMENSIONS: 0.005" (0.005" MIN)				
TOLERANCES: 0.005" (0.005" MIN)				
3 PL: 0.005" (0.005" MIN)				
ANGLES: 1.5°				
REV.	CAGE CODE	QTY	NO.	REV.
8	07M16			N/C
SCALE: NONE				
SHEET 1 OF 1				

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

CUTTER ASSY

647.3800

